

Work Order ID 59838

Friday, June 11, 2010 2:38:47 PM



Page 1

Item ID: D4021-9

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 6/11/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: MDate: 10/06/14 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4021	B

100



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

16 Ø _____
TURN AS PER FOLIO FA 868 AND DWG D4021
DWG REV: B
FOLIO REV: B

10/06/19

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

16 Ø _____

10/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan

Code

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

MWZ
10/06/21

16 *0*

130



Packaging

Packaging

Identify as per dwg & Stock Location:

PAR

0.00

10/06/21 *(16)*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/22 *MF*

10-6-21

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, June 11, 2010 2:38:51 PM

Work Order ID: 59838



Parent Item: D4021-9



Parent Item Name: Bushing

Start Date: 6/11/2010

Required Date: 6/18/2010

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP
Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as
per dwg revB DD 10.04.20 verified by:EC

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ M304R.500	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 12.1000	Qty per Kit 0.083	Total 1.397895	Qty	Date	Status
304 SS roundbar .500													



Location	Loc Qty	Loc Code
MAT029	12.1	
113006	12.1	1.2 ft SD 10/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

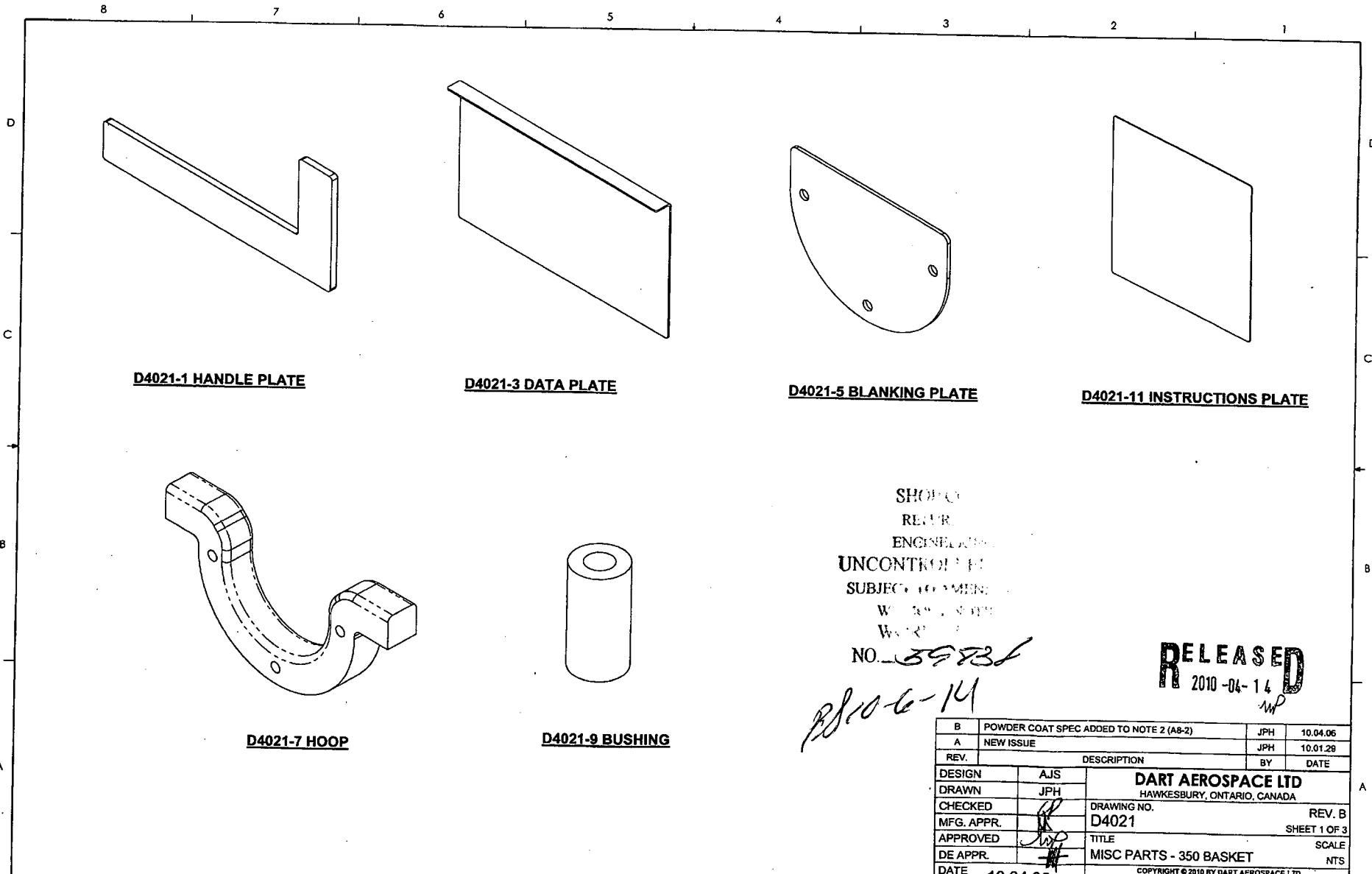
DART AEROSPACE LTD	Work Order:	598381
Description: Bushings	Part Number:	A4021-9
Inspection Dwg: Y021-9 Rev: R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10/06/20	Date:	10/06/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP
 RETURN
 ENGINEERED
UNCONTROLLED
 SUBJECT TO AMENDMENT
 WORKS DRAWING
 WORKS
 NO. 35831
 2806-14

RELEASED
2010-04-14

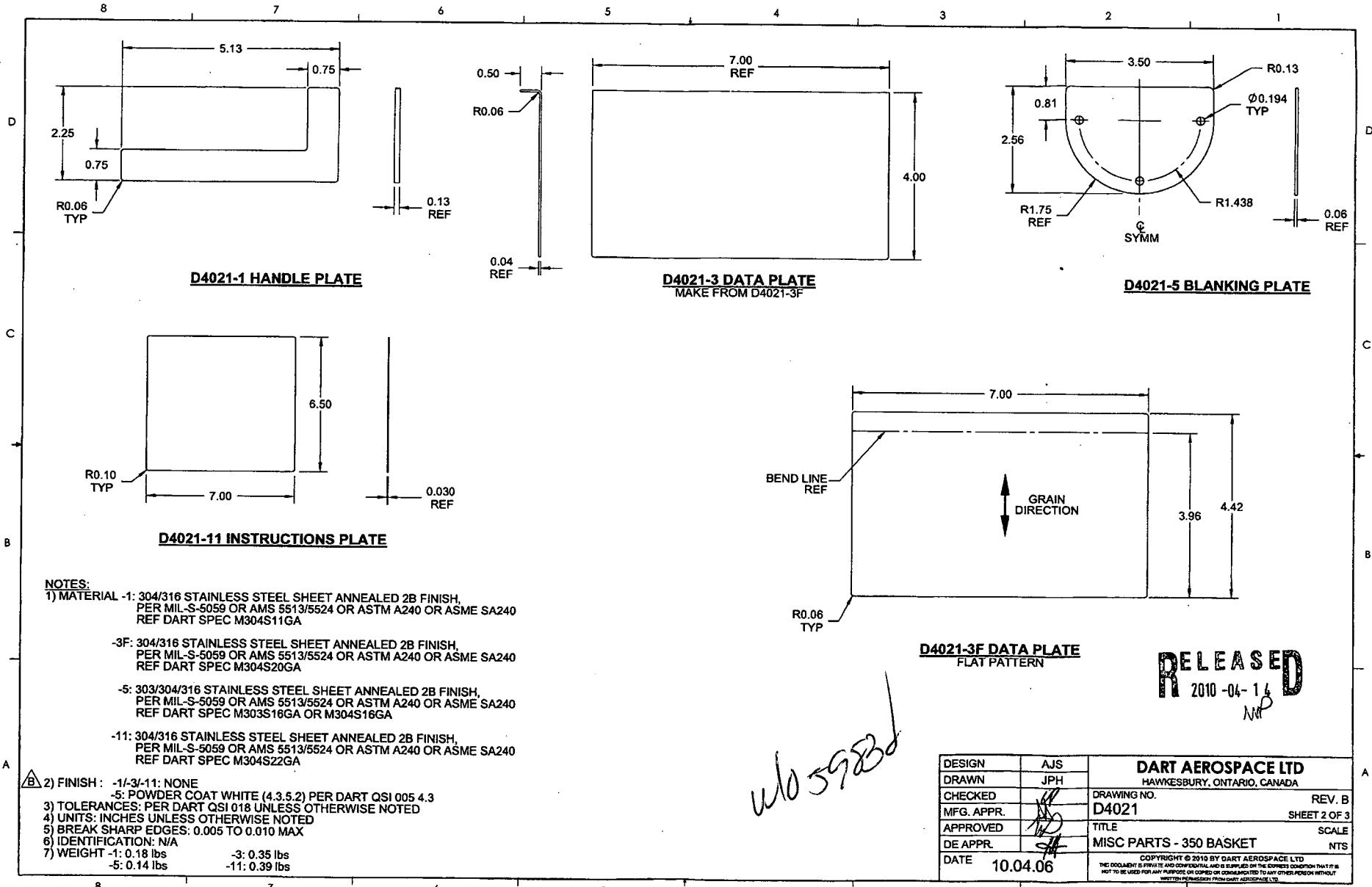
B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)		JPH	10.04.06
A	NEW ISSUE		JPH	10.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH	DRAWING NO.	REV. B	
CHECKED	S	D4021	SHEET 1 OF 3	
MFG. APPR.		TITLE	SCALE	
APPROVED	S	MISC PARTS - 350 BASKET	NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	10.04.06			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

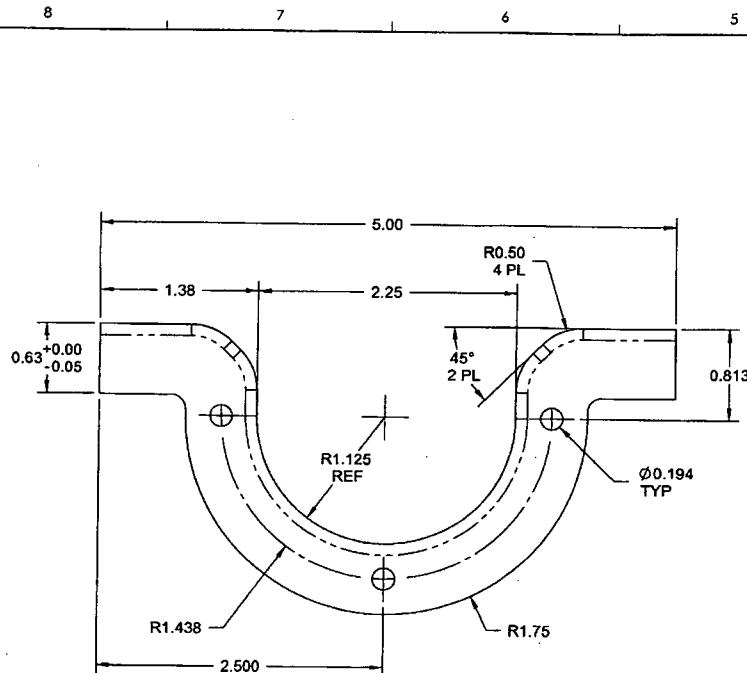
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

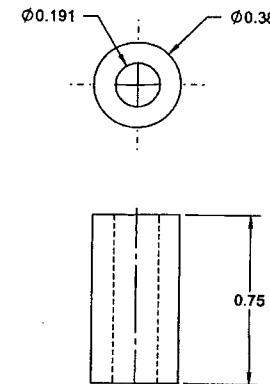
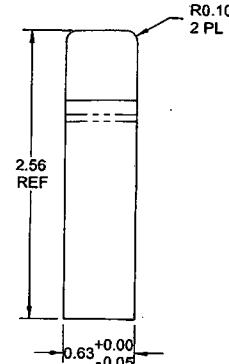
NOTE: Date & initial all entries



RELEASED
2010-04-14
NM



D4021-7 HOOP



D4021-9 BUSHING

W059838

RELEASED
2010-04-14

NR

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>(initials)</i>	DRAWING NO.
MFG. APPR.	<i>(initials)</i>	REV. B
APPROVED	<i>(initials)</i>	SHEET 3 OF 3
DE APPR.	<i>(initials)</i>	TITLE
DATE	10.04.06	SCALE
		MISC PARTS - 350 BASKET
		NTS

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